



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3190-1

Job Sheet 173691



Part No: D3190-1

Job Qty: 28 ea

Part Name: Chaffing Shield



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/6/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP A 03.05.26 New issue KJ/RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		4/5/18	0.00	0.00	Start Up Waterjet		DE 18/03/29
100	Waterjet	20 pcs		4/5/18	0.00	0.55	Waterjet1		DE 18/03/29
105	QC	20 pcs		4/5/18	0.00	0.00	QC8		EB
110	Small Fab	20 pcs		4/5/18	0.00	0.80	Small Fab-3		FF
120	QC	20 pcs		4/5/18	0.00	0.00	QC5		EB
124	HandFinish	20 pcs		4/6/18	0.00	0.95	HandFinish4		DE 18/04/04
127	QC	20 pcs		4/6/18	0.00	0.00	QC3		DAS 11 APR 09 2018
130	Packaging	20 pcs		4/6/18	0.00	0.00	Packaging3-1		6 9 APR 11 2018
140	QC21-SA	20 Ea		4/6/18	0.00	0.00	QC21		2-89

Part Op 100 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 105 - QC8- Inspect parts - second check

110 - 1- Roll as per Dwg D3190

120 - QC5- Inspect part completeness to step on W/O

124 - APPLY A THIN LAYER OF PROSEAL 890 TO CONCAVE SURFACE. (REF: AS PER DWG D407-667-245 (DEO

NOTE 15) A/R PROSEAL 890 BATCH: 138784 exp. 9/18

127 - QC3- Inspect Part Finish

130 - Identify as per dwg & Stock Location:

140 - QC21- Final Inspection - Work Order Release

DAS
21
9-80

APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S25GA	304/316 .020" Sheet 304 Sheet 25 Ga	4.3060 sf (.2153 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M304S25GA	4	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Chafing Shield	9.250inches ± 0.030	9.280 9.220		
2	Chafing Shield	3.130inches ± 0.030	3.160 3.100		



Container No: S056865



Part: D3190-1
Job No: 173691
Serial No/Batch: S056865
Revision:
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K84 1K7
CANADA
TEL.: 1 813 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/29/18

BAU
11
BAU
2
BAU

3

Chafing Shield

0.020inches $\pm$ 0.010

0.030

0.010

Plex 3/6/18 12:56 PM Dart.lajeunesse.marie